

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017377**Date Inspected:** 30-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 2G-067 of SB018-094 for SB94W. The welder is identified as 062808. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld is identified as 2F-013 of BK004A2-004 for BK004A-004. The welder is identified as 062752. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

FCAW welding of weld is identified as 2G-006 of BK005A8-002 for BK005A-002. The welder is identified as 062762. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld is identified as 4G-008 of BK004B1-001 for BK004B-001. The welder is identified as 208632. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2234-B-U2-F.

FCAW welding of weld is identified as 3G-118 of BK004A5-001 for BK004A-001. The welder is identified as

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62806. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld is identified as 2F-048 of BK004A6-013 for BK004A-013. The welder is identified as 062755. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

FCAW welding of weld is identified as 3F-124 of BK006A5-002 for BK006A-002. The welder is identified as 062786. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133.

ZPMC personnel performing HSR of bike path BK005A-001 deck plate ends after ZPMC and CT NDT completed and accepted satisfactorily. But ZPMC has internal report to perform this HSR  
The report is identified as HSR1 (B)-9311 dated on 09.09.2010.

During in process inspection it is found that weld joint fit-up of bike path bottom end cover plate ZPMC not following approved WPS and WD. The weld is identified as BK005A2-001-016,018. As per WPS it has CJP weld with square groove but ZPMC made single V groove and finished their welding. This is informed to ZPMC QC Mr.Xu tao and ABF QA Mr.Peng wen jun.  
For more information please see the attached photos.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-007

BK004A3-007-010,020,022,034,041,057

BK004A4-007-008,019,023,035,048,056,057,072,076

BK004A8-007-072,073,024,121,126,038

BK004A2-007-001,004,005,011

BK004A6-007-036,155,156,128,150

BK004A5-007-003,005

This QA inspector performed VT of welds areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated a VT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-007

BK004A3-007-065,100,067,101,068,102,069,103,070,104,071,105

BK004A4-007-080,100,083,102,082,101,085,103,086,104,087,105

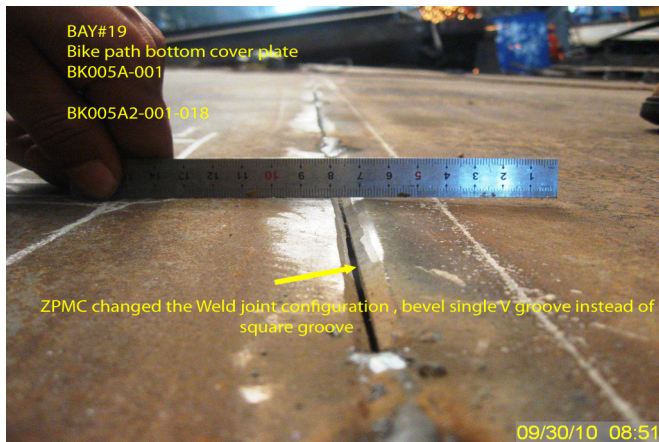
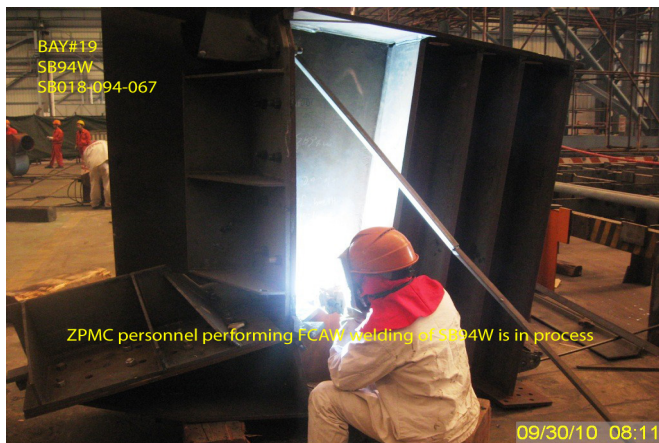
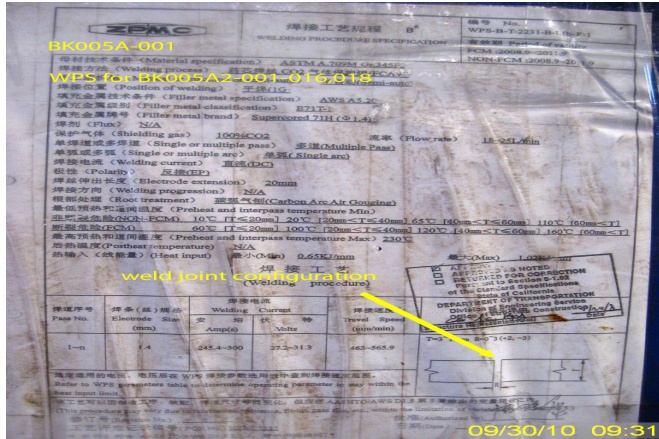
BK004A6-007-004,006,009,011,003,005,008,010,025,027,037,039

BK004A8-007-004,006,009,011,025,027,037,039

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer